



Solid Core



Hollow Core



Fire (B-Label)



X-ray

DOORS

By

Roddiscraft

**One Source for All
Your Requirements**

Quality for Over 60 Years

**RODDIS PLYWOOD CORPORATION
MARSHFIELD, WISCONSIN**

lightweight . . . warp-free . . . low sound and heat transmission

Advanced safety features that guard life and property are built into Roddiscraft B-Label wood-faced fire doors approved by the Underwriters' Laboratories for use in B and C fire hazard classification openings.

For effective fire protection, Roddiscraft B-Label fire doors are used in many institutions, including hospitals, schools and business establishments for stairway and room entrances, dumb waiter and fire escape openings. For residences, there's a growing trend to use these doors for bedrooms, basements, and for entrances where a garage is connected directly to the house.

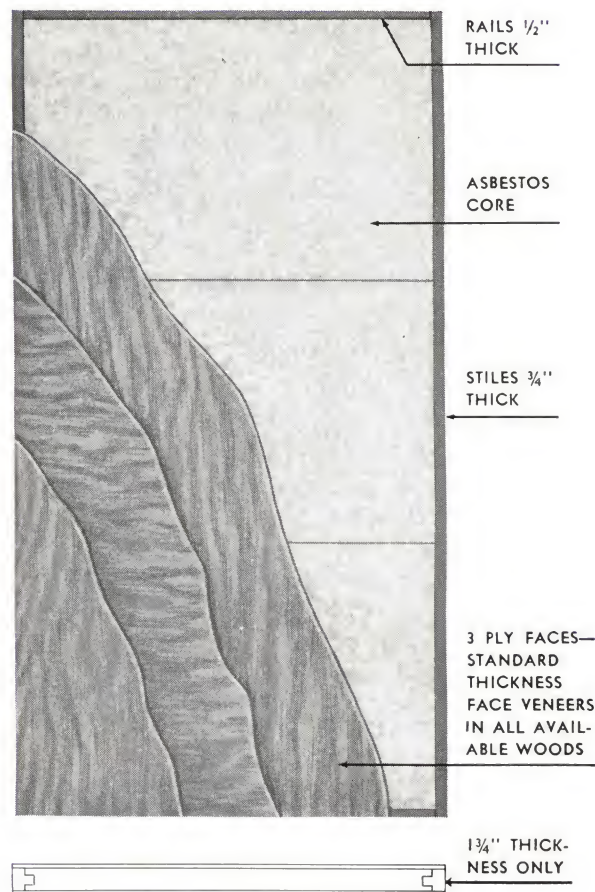
Produced in all available wood species, the Roddiscraft B-Label fire doors permit architects and builders to match their fire doors with conventional Roddiscraft flush doors in a building.

Manufactured in standard and also to specified sizes, these B-Label fire doors are available in width up to 3½ feet and heights to 7 feet.

Construction Features

The core is made of a special asbestos compound that is non-combustible. The door is faced on both sides with plywood and the sides and top are banded with fireproofed lumber. To assure stability and eliminate rattling, the special asbestos core is made up with only three sections which are assembled together with a tight tongue-and-groove joint.

Other outstanding features include: It is lightweight, weighing 20% less than conventional solid core doors. This provides savings on shipping costs and handling is made easier. Also the door is warp-free, has a low sound transmission factor and low heat transmission.



When Planning Fire Safety Features In Any Building, Specify Roddiscraft B-Label Fire Doors

Specifications: Underwriters' Laboratories Approved, Seven-Ply, B-Label, Composite

1. GENERAL:

All doors, required to maintain the integrity of B and lower fire hazard classification openings, shall be seven ply Underwriters' Laboratories approved Roddiscraft B-Label fire doors manufactured by the Roddis Plywood Corporation, Marshfield, Wisconsin, and labeled accordingly.

- A. Doors shall be constructed in strict accordance with the procedures and specifications approved by the Underwriters' Laboratories and shall be covered by the Roddis two-year Guarantee Bond.
- B. Doors shall be manufactured accurately to the specifications and limitations as approved by the Underwriters' Laboratories. The size shall not exceed 3'6" x 7'0", and the thickness shall not deviate from the approved thickness of 1-3/4".

2. CORE:

The core shall consist of three well-balanced sections of a rigid, incombustible, inorganic bonded, long-fibered asbestos panel having an approximate density of 23 pounds per cubic foot, and approved for this service by the Underwriters' Laboratories and the United States Coast Guard. The three sections shall be joined tightly together with a well-fitting tongue and groove joint, as approved by the Underwriters' Laboratories, and the assembly shall be railed

with Class A fireproof Birch lumber, 3/4" thick on the sides, and 1/2" thick in the top and bottom edges. The rails shall be joined to the core assembly with a well-fitting tongue-and-groove joint, as approved by the Underwriters' Laboratories, and the assembly sanded to a uniform thickness.

3. FACE PANELS:

The core assembly shall be faced on each side with a three-ply panel having a thickness of 1/8". The face of this three-ply panel shall be well dried, standard thickness veneers** laid with the grain perpendicular to that of the core veneer. The back shall be well-dried, sound, standard thickness hardwood veneer with the grain laid parallel to the face veneer and perpendicular to the core veneer. This three-ply panel shall be pre-assembled before being applied to the core. The face, core, and back veneers of each panel shall extend the full width and length of the door.

A. Face veneers shall be as follows:

Note: Here describe any special requirements of species, figure, pattern, etc. If more than one type is required, specify each separately and locate here, or by reference to door schedules or special detail drawings.

4. ADHESIVES:

The core and rails shall be bonded together with resorcinol water-

Underwriters' Laboratories Approved



This metal Underwriters' Laboratories approved label is fastened to every Roddiscraft B-Label Fire Door.

Outstanding Features

- Non-combustible core of special asbestos compound.
- Faced on both sides with plywood . . . in all available wood species.
- Available in widths up to 3½ feet . . . heights up to 7 feet.
- 20% lighter than conventional solid core doors for lower shipping costs . . . easier handling.
- Warp-free, low sound transmission, low heat transmission.
- Completely stable core—no chance of rattling. Three sections are assembled with tight tongue-and-groove joint.

Installation and Hardware Recommendations for Roddiscraft Fire Doors

The Underwriters' Laboratories recommend that Roddiscraft B-Label fire doors used for vertical shaft and corridor openings be hung and equipped as follows:

The Label is placed one-third down from the top edge of the door on the hinge side in manufacture. The label should be at the top when the door is installed. This label is not to be removed for any reason.

Clearance. The maximum clearance shall be 1/16" at the top and sides and 3/16" at the bottom. To obtain proper width clearance and bevel, plane the lock edge only. The labeled edge is not to be trimmed or beveled. The top and bottom rails are 1/2" thick. Trim equal amounts off both to obtain proper height clearance.

Hinges. Fasten the door leaves of full-mortise and half mortise hinges to the door with 1-1/4" No. 12 flat head Type A sheet metal screws. The door leaf of full-surface and half-surface hinges should be bolted through the door as illustrated (see Page 6).



Fire Retardant Doors

proof adhesive. The entire core assembly shall be sized on two sides to assure a perfect bond of the face panels to the core. The face panels shall be pre-assembled with waterproof melamine or phenolic glue, as required by the species of veneer specified, and hot pressed until thoroughly cured. The face panels shall be assembled to the core with resorcinol waterproof adhesive and maintained under adequate pressure until completely cured.

5. SANDING:

Both door faces shall be thoroughly belt sanded to a smooth, even texture.

6. GLAZING:

(Not approved)

7. FITTING:

Here specify factory sizing and fitting of doors and hardware.

8. PAINTING AND FINISHING:

Here specify factory finishing.

****STANDARD THICKNESS FACE VENEERS**—Standard thickness of face veneers before sanding: Rotary cut or sliced plain figure Birch, Maple, Oak, Gum, Quartered Figured Gum, Walnut, Mahogany, and most foreign woods, 1/28 inch; White Pine, 1/16 inch; Quartered Oak, 1/24 inch.

(Installation and Hardware cont'd.)

The Underwriters' Laboratories specify that hinges for Class B, C, D, and E doors shall be full-mortise, half-mortise, half-surface, or full-surface. These are to be made of steel and not less than 4-1/2" in height and 0.134 in. in thickness. Also, olive knuckle steel hinges not less than 6 in. in height and 0.225 in. in thickness may be used. Two hinges shall be provided for doors up to and including 60 in. in height, and an additional hinge for each 30 in., or fraction thereof in height. Doors not exceeding 5 ft. in height and 3 ft. in width shall be provided with two hinges of the types and sizes, as specified above, or not less than 4" in height and 0.130 in. in thickness.

Locks. The Underwriters' Laboratories require that single-swing doors for Class B, C, D, and E openings be equipped with an Underwriters' Laboratories approved, single point lock having a minimum throw of 1/2". Either the tubular or mortise-type lock set may be used. The locks should be installed according to manufacturer's instructions. Those locks having screwless roses are recommended.

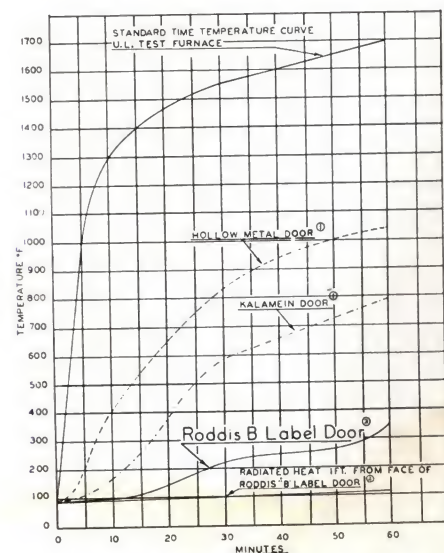
The Underwriters' Laboratories do not recommend hanging fire doors without a positive latch as the air currents created by a fire may cause the door to stand open, adding to the draft and losing the protection the door affords. Consequently, doors equipped with pull only are not approved.

Door Closers. The Underwriters' Laboratories have approved only the overhead, face-mounted and semi-concealed door closers. Those equipped with hold-open mechanisms are required to have a fusible link release incorporated in them. Floor mounted closers have not been approved.

Frames. The Roddis B-Label Fire Door should always be installed in Underwriters' Laboratories labeled steel frames—16 gauge for openings of 3'6" and under, and 14 gauge for openings over 3'6".

(For a list of suppliers of Underwriters' Laboratories approved hardware for use with Roddiscraft B-Label fire doors, write for FIRE PROTECTION EQUIPMENT LIST, published by Underwriters' Laboratories, Inc., 161 E. Sixth Ave., New York 13, N. Y.)

HEAT TRANSMISSION COMPARISON



- (1) From U.S. Senate Hearings on Safety at Sea
(2) From Fire Test Report Underwriters Laboratories

Confining fire is only one function of a fire door. The other is to retard the transmission of heat through the door, eliminating the possibility of igniting combustible materials contacting the other side of it. For example, dry paper will ignite when placed against a surface with a temperature approaching 500° F.

As shown in the graph, even though one side of the Roddiscraft Fire Door was subjected to temperatures of 1700° F. in this sixty-minute test, the maximum radiated temperature, measured one foot from the opposite side, was only slightly over 100° F. The surface temperature of this side measured approximately 350° F. as compared to slightly over 1000° F. for hollow metal doors.

FIRE RESISTANT

The resistance of Roddiscraft Solid Core Flush Veneered doors to fire has been substantiated by independent laboratories where standard Roddiscraft doors have withstood a regular fire test for over 40 minutes. (For information on B-Label fire doors, see pages 2 and 3).

SOUND RESISTANT

Roddiscraft standard 1-3/4" Solid Core doors developed an average sound transmission loss of 30.9 decibels. This is only

a little less than specially constructed sound resistant doors of much greater cost.

RESISTANT TO ABUSE

Core, crossbandings and face veneers are welded into a single unit with the inherent strength of true plywood construction.

WATERPROOF

Use of phenolic resin glue provides two completely waterproof shields over the entire area of the door. Doors are suitable for both interior and exterior applications.

Compare the advantages of Roddiscraft construction over heavy face veneer construction

Because of grain characteristics of wood, sharp blow is more likely to cause chipping here, rather than dent, requiring replacement of veneer or extensive sanding.



Heavy face veneer construction

Dents affect face & crossbanding as a unit — can be raised by applying water and hot iron.

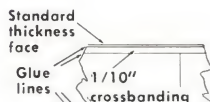


Roddiscraft construction

If face veneer is gouged out, matching replacement is relatively easy with standard thickness face veneers.



Heavy face veneer construction
Veneers are held at glue line, but excessive thickness makes exposed surface vulnerable to temperature & humidity changes



Roddiscraft construction
Waterproof glue line close to surface prevents movement of face veneers caused by climatic action

Standard thickness face

VERTICAL GRAIN FACE VENEER

CROSS BANDING VENEER

SOFTWOOD STAVED CORE

Quality for
Over 60 Years

Specifications: Solid Core Flush Veneered Doors for Exterior and Interior Use

General

All doors (so indicated on plans) shall be five-ply Flush Veneered doors made by Roddis Plywood Corp., Marshfield, Wisconsin. Doors shall be constructed in strict accordance with Roddiscraft Standard Construction covered by their two-year Guarantee Bond, and permanently identified with the red-white-and-blue dowel. Doors shall be of sizes and thicknesses called for.

Cores

Cores shall be made of low density* wood blocks no more than 2 1/2" wide of varying lengths assembled with the grain running parallel and vertically (from top to bottom of door). Cores shall be railed on two sides with 3/4" thick hardwood strips—double thickness strips top and bottom of any hardwood or softwood. Those on side edges to be same kind of wood as face veneer. The whole assembly shall be glued under pressure with water-resistant Resin Glue and thoroughly kiln dried, seasoned and planed smooth.

Crossbandings

Crossbandings of 1/10" thick, thoroughly dried, hardwood veneer shall be laid with the grain at right angles to that of the core and glued with waterproof phenolic resin glue (pressure and heat) to both sides of the core. Crossbandings shall run full to the four edges of the door.

Face Veneers

Thoroughly dried, standard thickness face veneers** laid with the grain at right angles to that of the crossbandings, shall be glued with phenolic resin glue (pressure and heat) to both faces of the door and belt sanded smooth.

Face veneers shall be as follows: NOTE: Here describe any special

requirements of species, figure, pattern, inlays, etc. If more than one type is required, specify each separately and locate here or by reference to door schedules or special detail drawings.

Metal Door Bottoms and Glazing Strip

All exterior doors shall be provided with 28-gauge copper moisture-protecting door bottoms (and glazing strip) in accordance with Roddiscraft standard details.

Glazing

(Not by door manufacturer)—All glass for glazed doors shall be (specify).

Glazing shall be in accordance with details, using removable wood glazing molding set in white lead or varnish to seal against moisture absorption.

Where called for, doors shall be equipped with (specify grade and type—specify size) mirrors in accordance with details.

Fitting

Here specify factory sizing and fitting of doors and hardware.

Painting and Finishing

... are specify factory finishing.

*Low density wood blocks are those weighing not more than 2300 pounds per 1000 board feet when kiln dried to a moisture content of 6%.

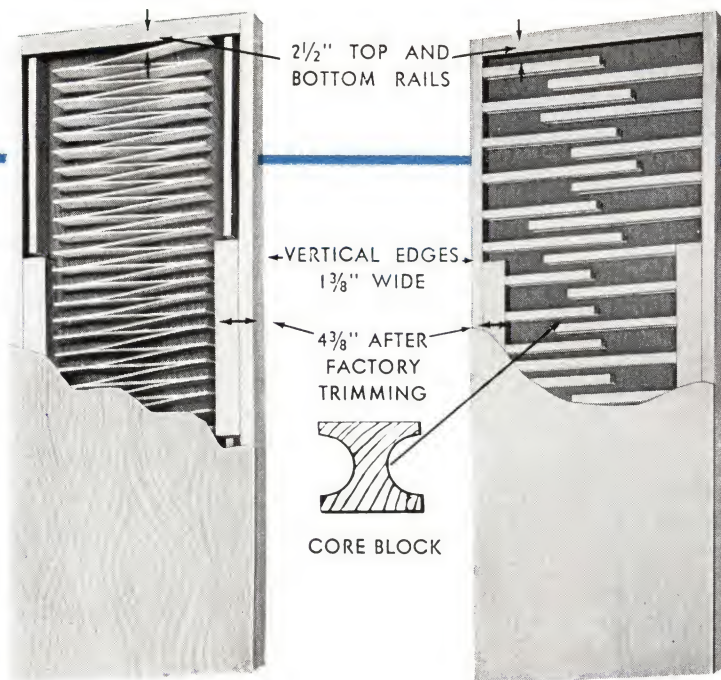
**Standard thickness of face veneers before sanding: Rotary cut or sliced plain figure Birch, Maple, Oak, Gum, Quartered Figured Gum, Walnut, Mahogany, and most foreign woods, 1/28"; White Pine, 1/16"; Quartered Oak, 1/24".

LOOK FOR THE RED-WHITE-AND-BLUE DOWEL!

Roddiscraft

FLUSH VENEERED DOORS

Housemart Hollow Core



Accordion type veneer core
Identified by the Red Dowel

Fluted block core
Identified by the Blue Dowel

The two types of Roddiscraft Hollow Core doors are illustrated above. Selected strips of veneer are spot glued at intervals to form the design of the accordion type core. Wood strips in the block core are fluted to save weight without sacrificing strength.

Extra-strength . . . light weight

Roddiscraft offers two types of hollow core doors which are alike in all respects except for core construction—accordion type veneer core and fluted block core.

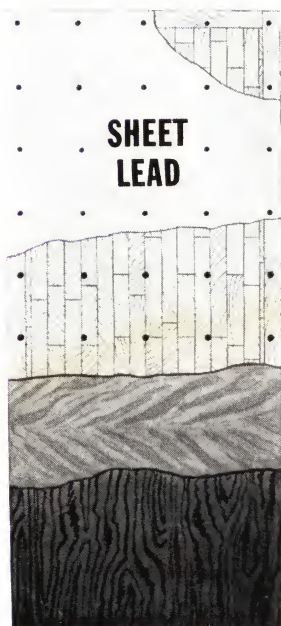
Built into the famous Housemart Hollow Core Door is the same high quality which has made the Roddiscraft Solid Core Door the favorite of numerous architects for years.

CONSIDER THESE ADVANTAGES

1. Every Roddiscraft Housemart Door has pleasingly matched, standard thickness face veneers . . . for color and grain.
2. Standard door sizes as well as specified sizes are manufactured in all available woods.
3. Roddiscraft factory finishes Housemart doors to specification . . . cuts louvre and light openings . . . installs louvres on specification.
4. Eased edges of face panels prevent splitting and chipping in handling.
5. Adequate and proper face support in combination with electronic bonding assure smooth, even faces.
6. Housemart doors carry the Roddiscraft two-year Guarantee Bond, your assurance of satisfactory service. (See Page 8 for guarantee details).

X-Ray

Roddiscraft FLUSH VENEERED DOORS



Designed for beauty . . . with complete protection

Here's the answer to providing complete safety for personnel working with X-ray equipment. The Roddiscraft X-ray doors are designed for good looks. They match regular Roddiscraft Flush doors. Equipped with a continuous sheet of lead set midway between a divided wood core, the X-Ray Door is otherwise identical to the famous Roddiscraft Solid Core Door.

Roddiscraft X-Ray doors are manufactured only on special order. Any thickness of lead may be specified according to the amount of protection required.

Specifications

X-Ray Proof doors (so indicated on plans) shall be Roddiscraft X-Ray doors manufactured by Roddis Plywood Corporation, Marshfield, Wisconsin.

Divided wood cores composed of softwood strip-blocks bonded together under heat and pressure with urea resin glue and banded four sides shall house a continuous sheet of lead running full to the four edges of the door. This assembly shall be secured by the use of lead covered bolts spaced 8" on centers. 1/10" hardwood crossbandings and standard thickness face veneers shall be bonded to the core under heat and pressure with phenolic resin glue and the doors belt sanded smooth.

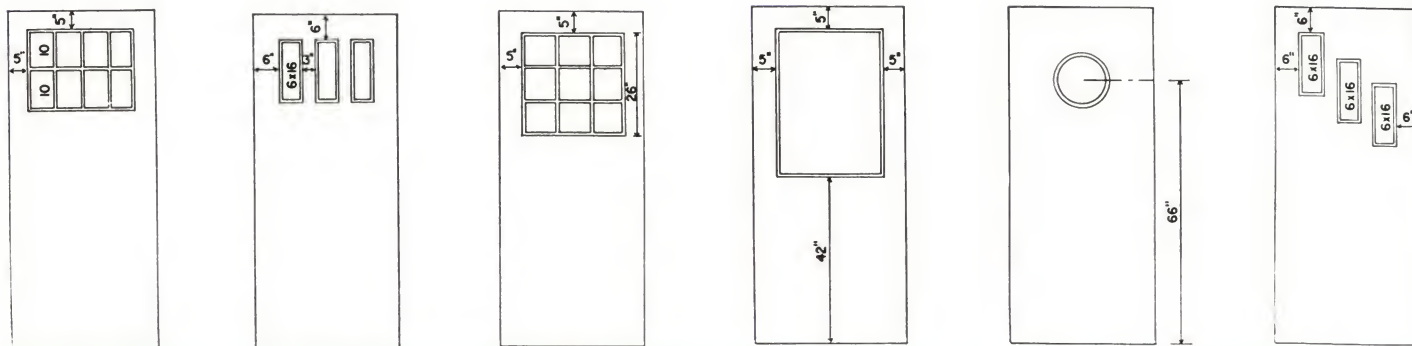
Vertical edge strips shall be of same species as face veneers. Lead thickness shall be as indicated on plans.

Roddiscraft Does the Complete Job

FACTORY-FINISHED DOORS—Roddiscraft doors can be furnished completely factory finished to architectural specification.

DETAIL WORK—Numerous door installations require light and louvre openings and louvre installation. Roddiscraft is equipped to perform these detail operations to specification. Construction methods used are time tested.

MOISTURE PROTECTION—When specified, Roddiscraft installs copper glazing strips at the bottom of light openings and at the bottom edges of doors. Roddiscraft recommends that when millwork firms install glazing, the stops on the exterior sides of the light openings be set in white lead or spar varnish, and the glass imbedded in putty.



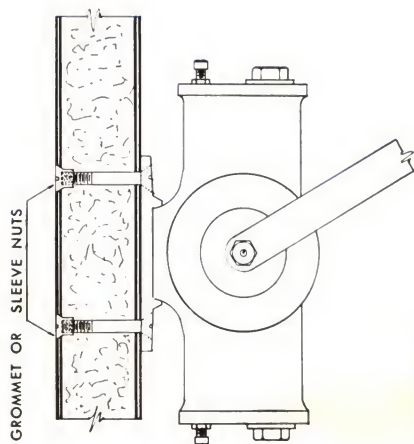
Illustrated above are several representative glass layouts for Flush Doors.

details

Roddiscraft B-LABEL FIRE DOORS

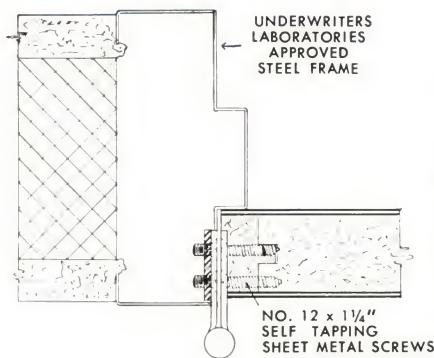
Preferred method of installing tubular lock, half surface hinge, door check mounting, full mortise hinge

DOOR CHECK MOUNTING



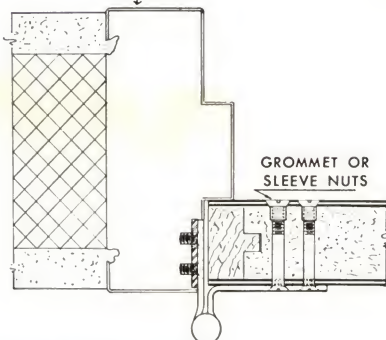
DOOR CHECKS WITH HOLD-OPEN ARM MUST BE EQUIPPED WITH A FUSIBLE LINK RELEASE

FULL MORTISE HINGE

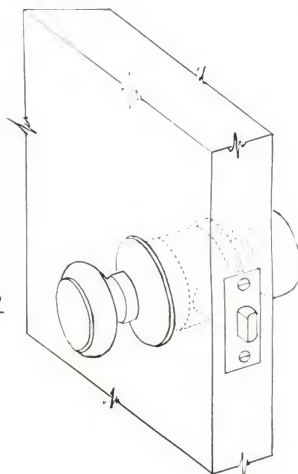


NO. 12 x 1 1/4" SELF TAPPING SHEET METAL SCREWS

UNDERWRITERS LABORATORIES APPROVED STEEL FRAME



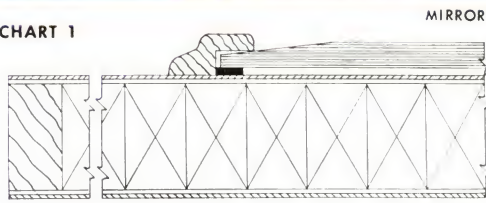
HALF SURFACE HINGE



TUBULAR LOCKSET

CHART 4A

CHART 1

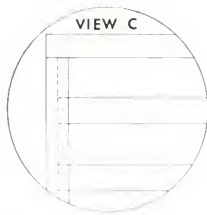


MIRROR DOOR — MIRROR PLANTED ON

STANDARD LOUVRE CONSTRUCTION FOR FLUSH DOORS



SECTION A

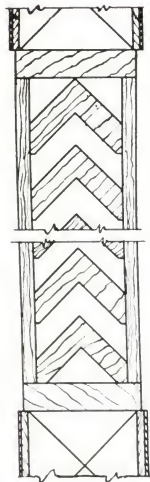


SECTION B

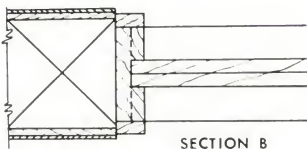
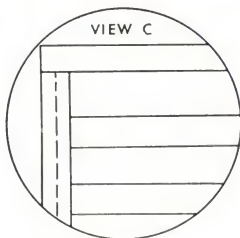
CHART 2



CHART 3



SECTION A

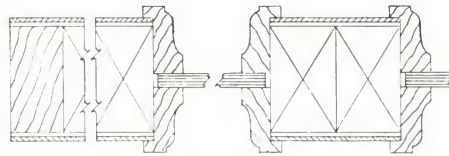


SECTION B

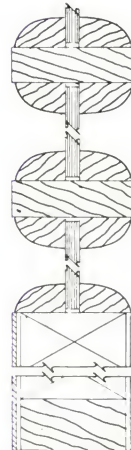
STANDARD CONSTRUCTION LIGHT-PROOF
V LOUVRE FOR FLUSH DOORS

CHART 1A

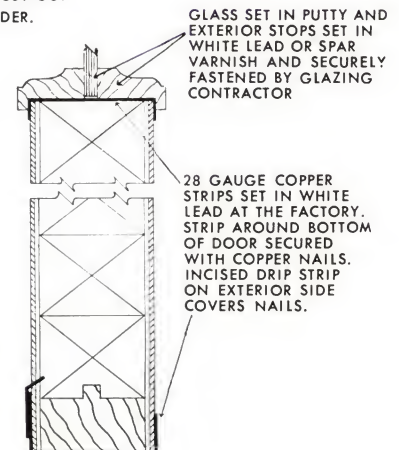
FLUSH DOOR
LIGHT OPENING DETAILS



INDIVIDUAL LIGHT OPENINGS CUT OUT
WHEN BARS ARE 1" OR WIDER.



SOLID BARS
USED WHEN
MEASUREMENTS
ARE LESS THAN 1"



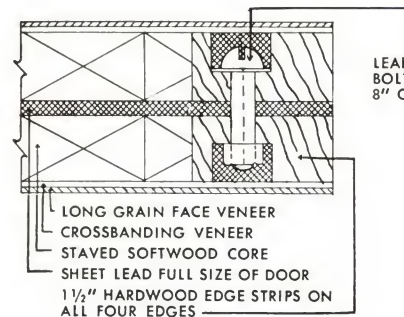
GLASS SET IN PUTTY AND
EXTERIOR STOPS SET IN
WHITE LEAD OR SPAR
VARNISH AND SECURELY
FASTENED BY GLAZING
CONTRACTOR

28 GAUGE COPPER
STRIPS SET IN WHITE
LEAD AT THE FACTORY.
STRIP AROUND BOTTOM
OF DOOR SECURED
WITH COPPER NAILS.
INCISED DRIP STRIP
ON EXTERIOR SIDE
COVERS NAILS.

RECOMMENDED MOISTURE
PROTECTION FOR EXTERIOR DOORS

CHART 4

STANDARD FLUSH X-RAY DOOR — LEAD LINED



LEAD COVERED
BOLTS SPACED
8" ON CENTERS

LONG GRAIN FACE VENEER
CROSSBANDING VENEER
STAVED SOFTWOOD CORE
SHEET LEAD FULL SIZE OF DOOR
1 1/2" HARDWOOD EDGE STRIPS ON
ALL FOUR EDGES

Large detail drawings of the items shown above, plus others as listed below, are available on request. Write to the nearest Roddiscraft warehouse for any or all of the following:

Chart No. 1 — Mirror door construction.

Chart No. 1A — Flush door light opening details and copper glazing strip detail.

Chart No. 2 — Standard louvre construction for flush doors.

Chart No. 3 — Standard construction light-proof V louvre for flush doors.

Chart No. 4 — Standard flush X-ray door.

Chart No. 4A — Preferred method of installing B-Label Fire Door hardware.

Chart No. 5 — Sound resistant door installation.

Chart No. 6 — Stock detail—Dutch door shelf and brackets.

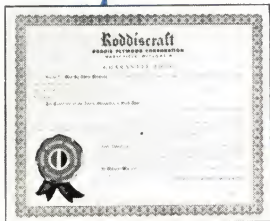
Chart No. 6A — Applied moldings for flush doors.

Chart No. 7 — Glass layouts for flush doors—R605, R615, R619, R643, R611.

Chart No. 8 — Glass layouts for flush doors—R636, R629, R633, R613, R601.

Chart No. 9 — Glass layouts for flush doors—R604, R600, R602, R621, R603.

Roddiscraft Doors are guaranteed for 2 YEARS



The Standard Door Guarantee of the National Woodwork Manufacturers Association listed below is the basis for the Roddiscraft two-year guarantee. While the NWMA guarantee covers one year, the Roddiscraft guarantee covers a two-year period. The Roddis Plywood Corporation is a member of this organization.

All doors produced by members of the National Woodwork Manufacturers Association, Inc., are guaranteed by the manufacturer for one year from date of shipment by the manufacturer to be of good material and workmanship, free from defects which render them unserviceable or unfit for the use for which they were manufactured. Natural variation in the color or texture of the wood are not to be considered as defects.

Doors must be accorded reasonable treatment by the purchaser. Doors

must be stored or hung only in dry buildings and never in damp, moist or freshly plastered areas. Doors must not be subjected to abnormal heat, dryness or humidity. The utility or structural strength of the door must not be impaired in the fitting of the door, the application of the hardware, or cutting and altering the door for lights, louvers, panels and any other special details. Immediately after fitting, the entire door including top and bottom edges must be painted, varnished or sealed to prevent undue absorption of moisture. The manufacturer will not assume responsibility for doors which become defective because of failure to follow the above recommendations.

A warp or twist of not to exceed 1/4 inch shall not be considered a defect.

Doors must be inspected upon ar-

rival for visible defects and all claims or complaints based thereon must be filed immediately and before the doors are hung and before the first coat of painter's finish is applied.

The manufacturer agrees to repair or replace in the white, unfitted and without charge, any door found to be defective within the meaning of this guarantee.

Doors must not be repaired or replaced without first obtaining the consent of the manufacturer.

Interpretation of Standard Door Guarantee

"A warp or twist of not to exceed 1/4 inch shall not be considered a defect." This refers to any distortion in the door itself and not its relationship to the frame or jamb in which it is hung. Therefore, a warp or twist exceeding 1/4 inch shall be considered a defect only:

1. When warp is determined by applying a straight edge to the concave face of the door, or
2. When twist is determined by placing the face of the door against a true plane surface. A simple device to determine and measure "twist" may be made by placing two cross-members on a post, one about door height and the other slightly above the floor. The cross-members must be perfectly straight and true and plumbed into perfect alignment.

For the purpose of this Guarantee, a building shall be construed to be "moist" or "freshly plastered" if at the time of the delivery of the doors, or at any time subsequent thereto and prior to the completion of the painter's finish, including the painting, varnishing or sealing the entire door including top and bottom edges, the relative humidity in the room or rooms in which the doors are to be installed or stored as determined by use of a standard hygrometer, exceeds 50% at 70 degrees Fahrenheit.

USE Roddiscraft NATIONWIDE WAREHOUSE SERVICE

Each Roddiscraft warehouse is a service center equipped to assist you in every possible way.

Call on your nearest warehouse for information regarding the application of any of our products.

CAMBRIDGE 39, MASS.
229 Vassar Street

DALLAS 10, TEXAS
8200 Lovett Street

MILWAUKEE 8, WIS.
4601 West State Street

PORT NEWARK 5, N. J.
103 Marsh Street

CHARLOTTE 6, N. C.
123 E. 27th Street

DETROIT 14, MICH.
11855 East Jefferson Street

MIAMI 38, FLORIDA
255 N. E. 73rd St.

ST. LOUIS 16, MO.
3344 Morganford Road

CHICAGO 32, ILL.
3865 West 41st Street

HOUSTON 10, TEXAS
2403 Sabine Street

NEW HYDE PARK, L. I., N. Y.
1756 Plaza Ave.

ST. PAUL 4, MINN.
635 North Prior Ave.

CINCINNATI 4, OHIO
836 Depot Street

KANSAS CITY 3, KANSAS
35-53 Southwest Boulevard

NEW YORK 55, N. Y.
920 East 149th Street

SAN ANTONIO 6, TEXAS
727 North Cherry Street

CLEVELAND 4, OHIO
2717 East 75th Street

LOS ANGELES 58, CALIF.
2620 East Vernon Avenue

PHILADELPHIA 34, PA.
Richmond & Tioga Streets

SAN FRANCISCO 24, CALIF.
345 Williams Avenue

LOUISVILLE 10, KY.
1201-5 South 15th Street

SAN LEANDRO, CALIF.
720 Williams Street

RODDIS PLYWOOD CORPORATION
MARSHFIELD, WISCONSIN